

Date: Tuesday, 1/15/2008 9:49:59 AM  
User: Kim Johnston

## **Process Sheet**

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE ASSEMBLY  
Job Number : 36775B -2  
Estimate Number : 11180  
P.O. Number :  
This Issue : 1/15/2008 S.O. No. :  
Prsht Rev. : NC Project Number : N/A  
First Issue : / / Type : SMALL MED FAB Drawing Revision : E  
Previous Run : 35451B Material :  
Written By : Due Date : 1/22/2008 Qty: 100 Um: Each  
Checked & Approved By : 2/10/08 01/15  
Comment : Est Rev:A Removed from 9 Digi 05-12-02 JLM

## **Additional Product**

**Job Number:**



Seq. #: Machine Or Operation: Description :

1.0 D2281 Jack Saddle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2281 Saddle B35471 → 21x  
B36824 → 76x

2.0 D22827 Tube



Comment: Qty.: 2.0000 Each(s)/Unit Total : 200.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2 D2282-7 tube B22827 → 3

3.0 - LARGE FAB 1            LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-043 Saddle Assembly

~~Grind chamfers and ensure full penetration.~~

A/R ER316L SS Filling Rod M106762  
Dwg Rev: E

4.0 QC9 /5 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

→ 3.1 Small fab  
- grind weld and deburr holes SAD 08/03/20

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/15/2008 9:49:59 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE ASSEMBLY

Job Number: 36775B

Part Number: D2282043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

*EB08/03/25 (58)*

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*08/03/05 (58)*

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: GA.

*Sylvie*

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Do 8/03/05*

Job Completion



*MF*

*08-03-27*

*(58)*

*V*

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No:

PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

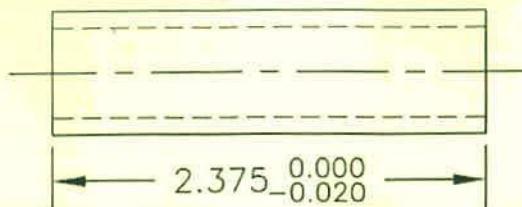
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

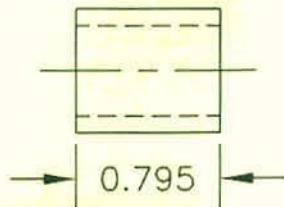
NOTE: Date &amp; initial all entries

**DART**

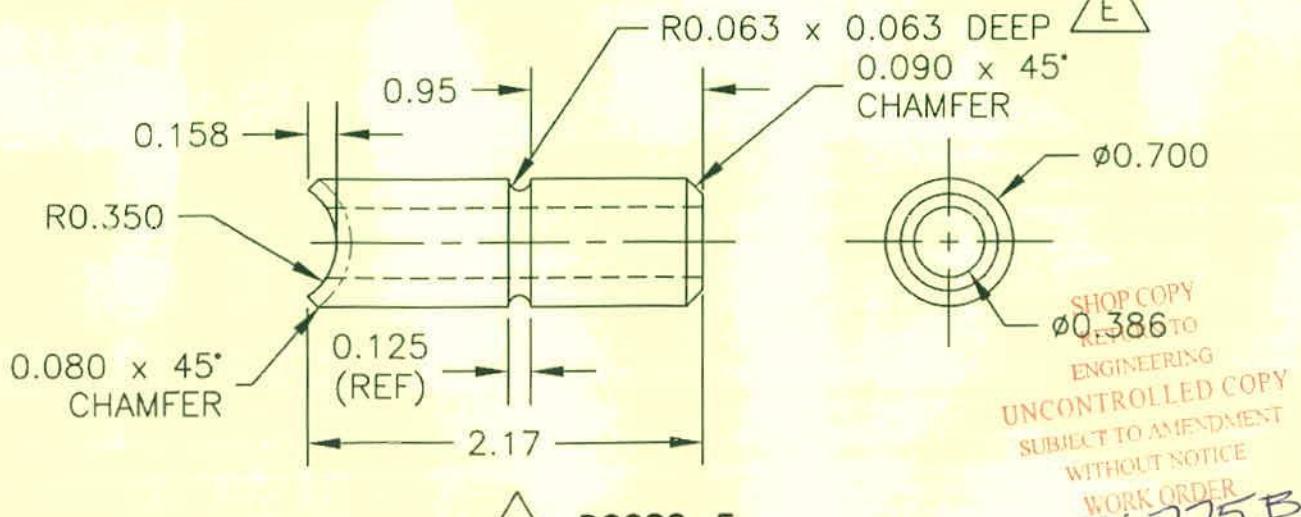
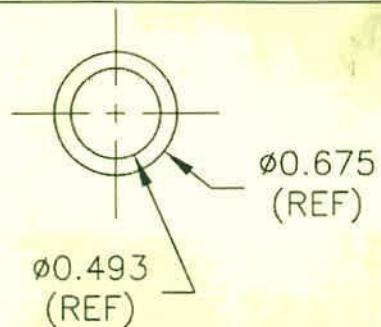
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	



D2282-3



D D2282-7



D D2282-5 E

D2282-5 STEM:

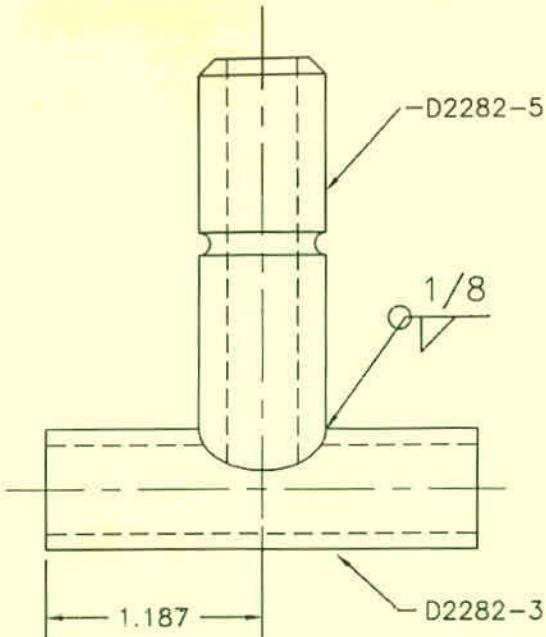
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



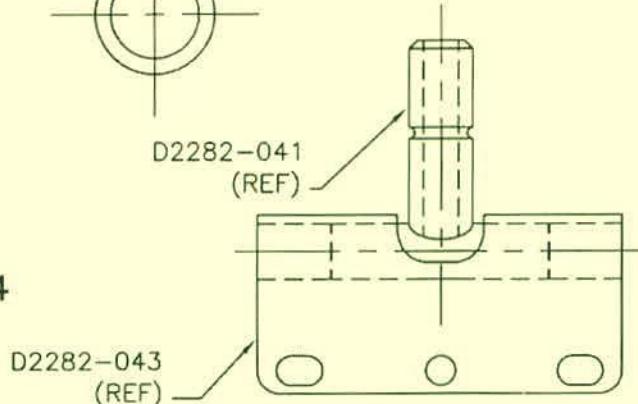
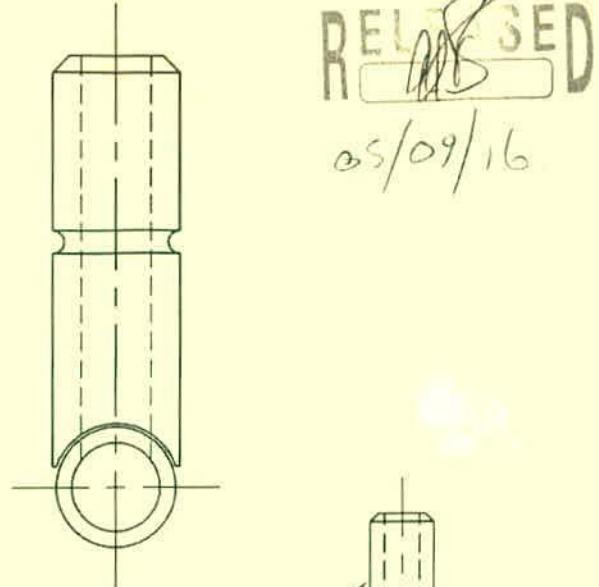




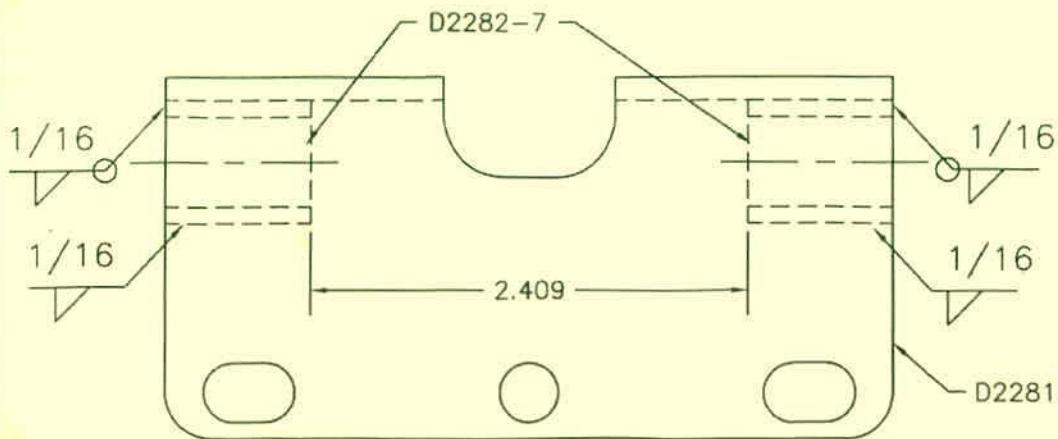
DESIGN BW	DRAWN BY <i>RF</i>	DART AEROSPACE LTD	
CHECKED <i>IP</i>	APPROVED <i>AB</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY  
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY  
SCALE 1:2



D2282-043 SADDLE ASSEMBLY  
WELD ASSEMBLY PER DART QSI 004

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36775B

10/12  
10/14

99  
c